

**ABSTRACT**

A ground electrode for a spark plug has a through hole located adjacent a firing end of the electrode, with a precious metal firing tip extending through the hole. The firing tip is compressed axially to define a bulging portion extending radially outwardly from its longitudinal axis to mechanically retain the firing tip within the through hole. The firing tip additionally has an enlarged head or otherwise expanded portion at each axial end of the tip to provide a second mechanical interlock of the tip to the ground electrode. The firing tip can then also be welded to further strengthen its connection to the ground electrode. A method of manufacturing the ground electrode and a spark plug containing the ground electrode is also disclosed.